

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009861**Date Inspected:** 03-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jha and Xu Yumin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trail Assembly**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) S. Manjunath. Math was present during the times noted above for observations relative to the work being performed.

Orthotropic Box Girder (OBG) Trial Assembly Area

Lift 2 East

This QA Inspector performed Ultrasonic Test along with Mr. Bert Madison to the Transverse Segment Weld for segment 2AE to 2BE at Side Panel, Cross Beam side weld no is identified as OBE2A-003. Prepared a consolidated report for the all the inspectors involved and noticed that 3(Three) indications were found and in which 1(one) indication was Class A reject, scanning was been carried out between Datum (Y) distance between 4700mm to 8245mm and consolidated report submitted to Mr. John Kinsey for review.

Segment 5CE to 5BE

This QA Inspector measured and recorded the dimension for Offset and Mis-alignment for Longitudinal Diaphragm for 5CE to 5BE at South (Bike Path) side and North (Cross Beam) side and found not in tolerance and same been informed to ABF engineer Mr. Weiping.

Segment 5AE to 5BE

WELDING INSPECTION REPORT

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This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Transverse Splice weld the back gouged areas. The weld joint is identified as OBE5A-008. The welder is identified as 066179. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2214-B-U2-FCM-1.

1AW to 1AAW

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Stiffener welded between I-Rib Stiffener for Deck Panel. The weld joint is identified as OBW1-025. The welder is identified as 220066. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233-Tc-U5-F.

1AW to 1AAW

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Stiffener welded between I-Rib Stiffener for Deck Panel. The weld joint is identified as OBW1-247 and 117 and 113. The welders were identified as 220066. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2234-U2-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath
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Quality Assurance Inspector

Reviewed By:	Carreon,Albert
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QA Reviewer
